

SPHIT-2

Work Order ID 43603 - 2



July 1, 2009 10:43:24 AM

Item ID: D3022-1

GY

Accept



Setup Start



Revision ID: B

Stop



Item Name: Seat Pan

Start Date: 7/15/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3022

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3022 ☐ Dwg Rev: ☐ Prog Rev: ☒

☐

*** grind direction along 31.700" ***

☐ 2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Work Order ID 43603



Page 2

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

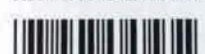
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form as per Dwg D3022

EL
9-7-1

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

- Sorlozki, PC

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Transfer drill Seat Pan From Frame
using D3017-041 *****2-Deburr

☐*****Transfer drill in D3022-1

- EL 9-7-1

Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 3

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Stop



Item Name: Seat Pan

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

- 502/07/01 @

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

09-07-01 (X)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:30AM

OVEN TEMPERATURE:

8:00AM FINISH TIME:

320°F

1109091

09-07-06

(X)

Work Order ID 43603

July 1, 2009 10:43:24 AM



Page 4

Item ID: D3022-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Seat Pan

Start Date: 7/15/09

Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

BK

09-07-06

0



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location

0.00

Store

9/1/06

12 SP



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

09/07/07



QC

Memo

0.00

Quality Control

U 9-07-07

Picklist Print

Page 1

July 1, 2009 10:43:24 AM

Work Order ID: 43603



Parent Item: D3022-1RevB



Parent Item Name: Seat Pan

Start Date: 7/15/09

Required Date: 8/03/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	111.0120	1.7086			
2024-T3 .032 sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	111.01	
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	
18147	3	

date: Thursday, 20/11/2008 3:34:26 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 43603 - 2
 Estimate Number : 11092
 P.O. Number :
 This Issue : 20/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LARGE FAB ASSY
 Previous Run : 43392

Drawing Name : SEAT PAN

Part Number : D30221 B
 Drawing Number : D3022 REV A
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 20/12/2008

Qty: 1 Um: Each

Written By :
 Checked & Approved By : JUD 08.11.21
 Comment : Est. C 02.01.23 Revised NG
 Est Rev:D 08-04-16 now water jet DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S032 2024-T3 .032 sheet



Comment: Qty.: 1.7044 sf(s)/Unit Total: 1.7044 sf(s)
 2024-T3 .032 sheet
 Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
 Batch: 110778 HB 9-2-10

(2)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3022
 Dwg Rev: B HB 9-2-10
 Prog Rev: B
 *** grind direction along 31.700" ***

→
PTU

2-Deburr if necessary HB 9-2-10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Sp 09/02/10 (2)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3022

Sp 09/02/23 (2)

ate:
ser:

Thursday, 20/11/2008 3:34:26 PM
Julie Dawson

Process Sheet

Drawing Name: SEAT PAN

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 43603

Part Number: D30221

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5096761 (20)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Transfer drill Seat Pan From Frame

*****Transfer drill in D3022-1 using D3017-041 *****

2-Deburr

EL 9-7-1 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5096761 (20)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Thursday, 20/11/2008 3:34:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 43603

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



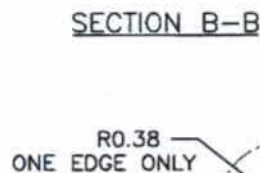
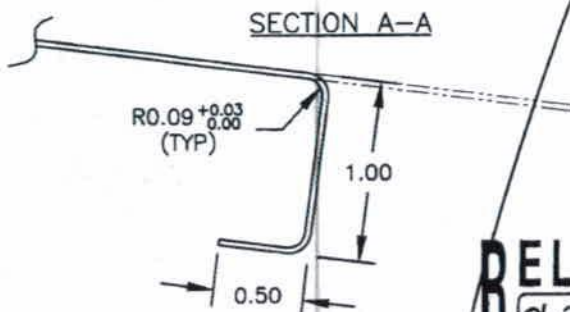
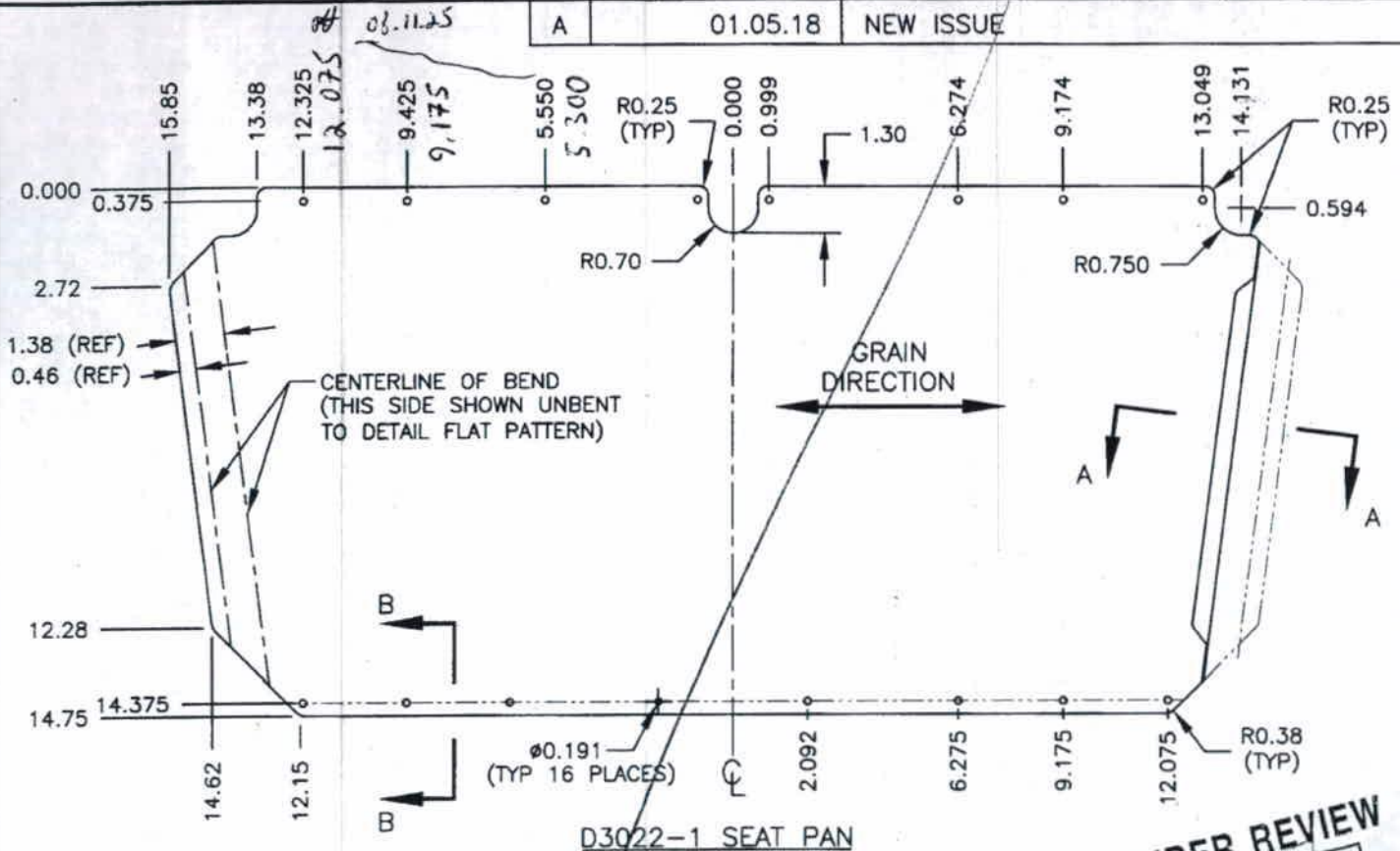
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3022	SHEET 1 OF 1
DATE	TITLE		SCALE
01.05.18	SEAT PAN		1:5
A	01.05.18	NEW ISSUE	

**RELEASED**
02.07**NOTES:**

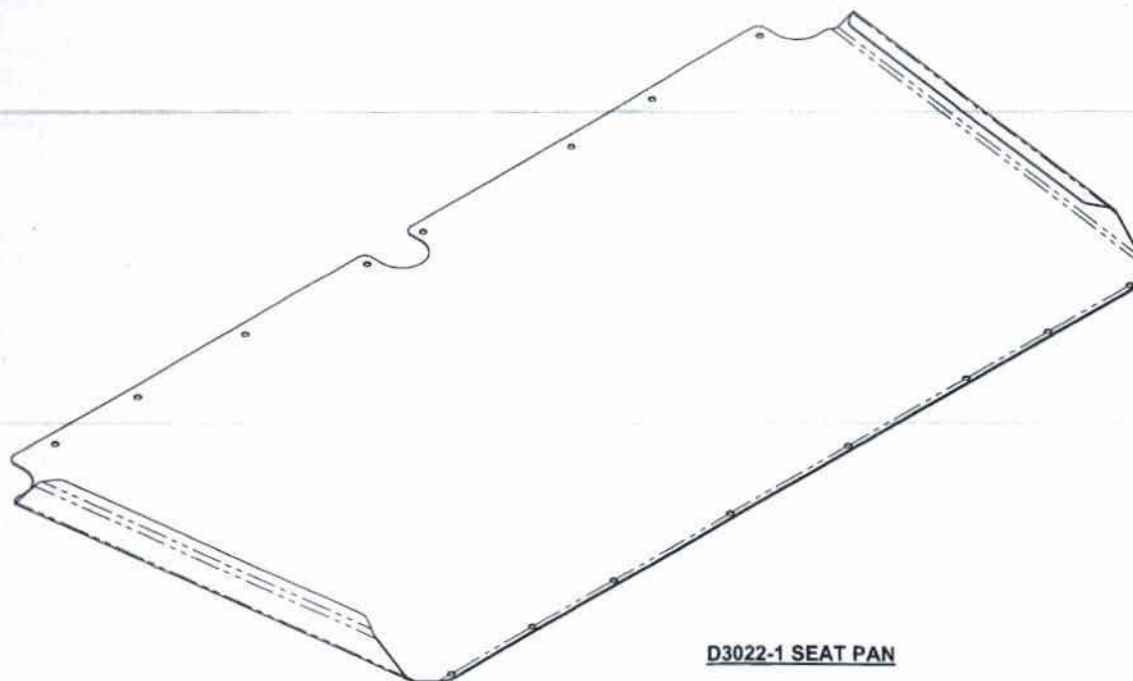
- 1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNDER REVIEW
03.04.17
DIMS 12.325,
12.075,
9.425,
13.049
SHOULD BE
SUBTRACTED BY 0.35
03.11.25

0.37
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 43603

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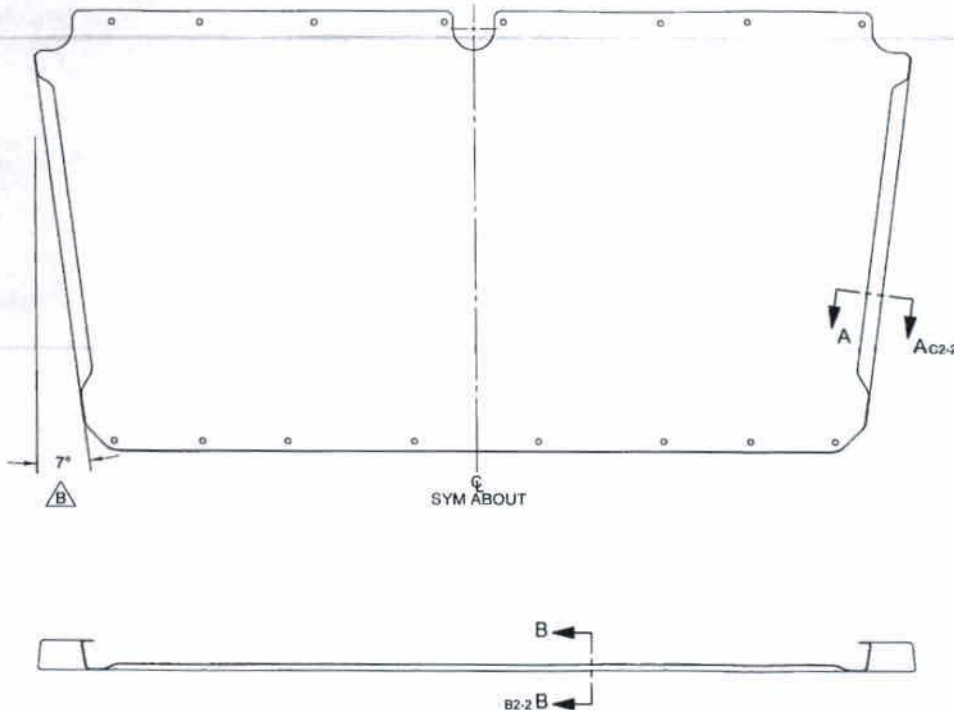
D3022-1 SEAT PAN

RELEASED
06/12/15 NWP

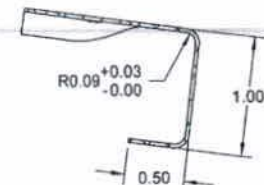
REFERENCE ONLY

43603

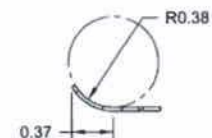
B		REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. B7-2 7" DIM ADDED. D7-3 12.075 WAS 12.325. D6-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.	AJS	08.11.27
A		NEW ISSUE	CP	01.05.16
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 TITLE SEAT PAN SCALE NTS SHEET 1 OF 3 REV. B		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED FOR YOUR USE ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	08.11.27			



D3022-1 SEAT PAN



SECTION A-A C4-2
SCALE 4X



SECTION B-B A5-2
SCALE 4X

RELEASED
08/12/15

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

REFERENCE ONLY

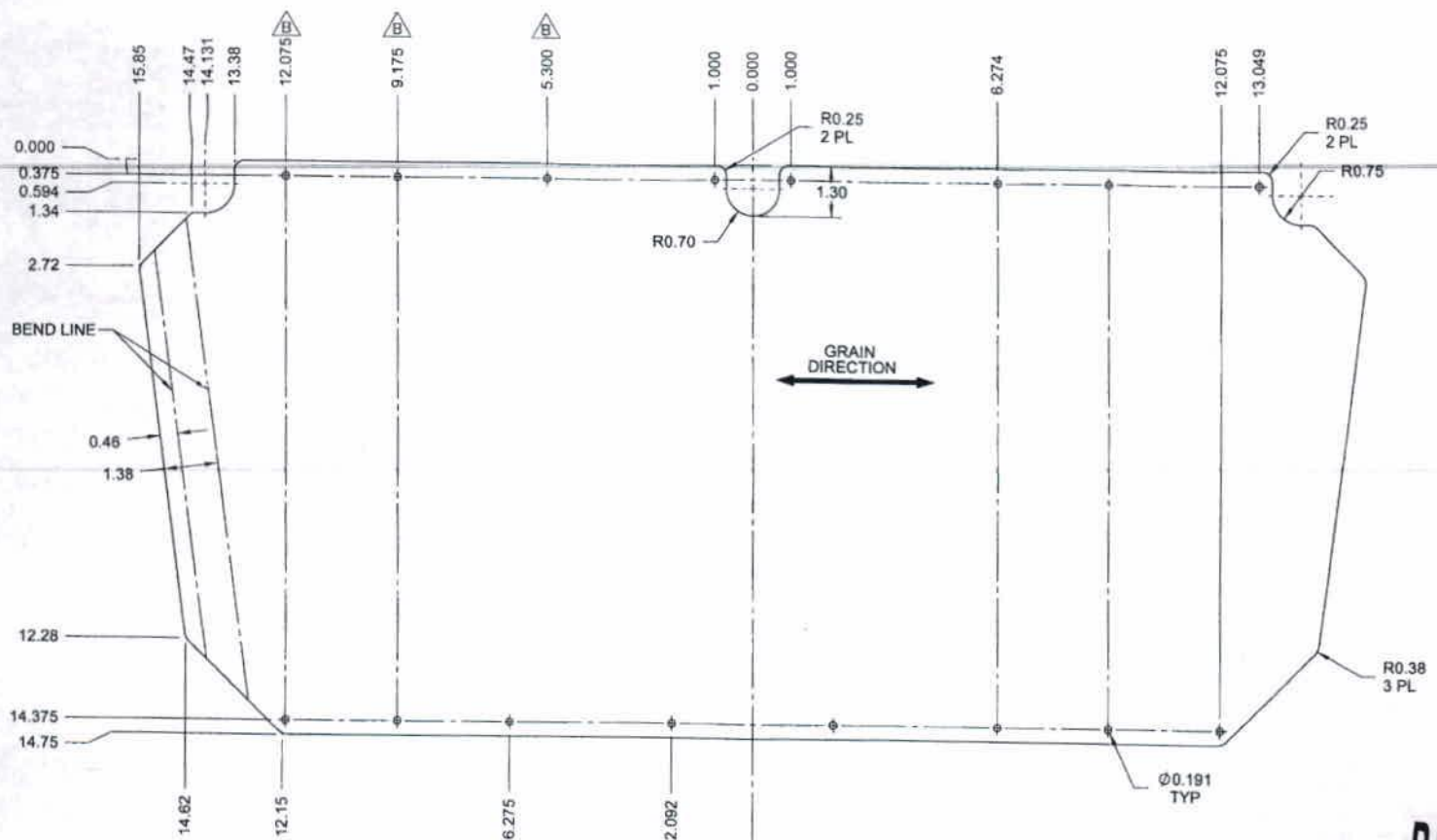
43603

DESIGN	CP
DRAWN	AS
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.11.27

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3022
TITLE
SEAT PAN

REV. B
SHEET 2 OF 2
SCALE
NT
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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

SYM ABOUT
UNLESS OTHERWISE
NOTED

43603

REFERENCE ONLY

RELEASED
208/12/15

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B SHEET 3 OF 3 SCALE NTS
DRAWN	AJS		
CHECKED		DRAWING NO.	
MFG. APPR.		TITLE	
APPROVED		SEAT PAN	
DE APPR.		DATE	08.11.27

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